

# Work Order ID 87918

\*87918\*

Page 1

July 18, 2012 11:20:46 AM

Item ID: D350-588-041 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Aft Door Assembly  
 Start Date: 7/18/12 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 8/17/12 Req'd Qty: 1.00 \*1\* Customer:  
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2445/D350-588	Rev D/D

100	DOCUMENT CONTROL	0.00							
*100*									
DC	Memo	0.00							
Document Control	Photocopy bluefile and create labels per PPP D350-588-041 CHG003								

110	PURCHASING	0.00							
*110*									
Purchasing	Memo	0.00							
Purchasing	Issue P/O: 17478								
	Description: D2445 Baggage Door								
	Supplier: Delastek								
	Ship to Delastek (1) D0588-041 label								
	Certification of Conformity and process sheet from Delastek is required.								

1  
 13-3-15

CL 12/07/18 (1)

# Work Order ID 87918

**\*87918\***

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July 18, 2012 11:20:46 AM

Item ID: D350-588-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Aft Door Assembly  
 Start Date: 7/18/12 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 8/17/12 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Receive & Inspect for Damage & Mat'l Certs	0.00							
<b>*120*</b>									
Packaging	Memo	0.00							
Packaging	Ensure Certificate of Conformity & Process Sheet are attached								
130	QC6- Inspect dimensions to drawing	0.00							
<b>*130*</b>									
QC	Memo	0.00							
Quality Control	Inspect as per Dwg D2445. Audit process sheet.								
140	Small Fab	0.00							
<b>*140*</b>									
Small Fab	Memo	0.00							
Small Fab	Assemble all of the above parts as per Dwg D350-588								

*Signature*

*Smd*  
*13219*

*1*

*ET 13-02-23*

# Work Order ID 87918

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Item ID: D350-588-041

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Aft Door Assembly

Stop **\*NS2\***

Start Date: 7/18/12 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 8/17/12 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC5- Inspect part completeness to step on W/O	0.00							
<b>*150*</b>									
QC	Memo	0.00							
Quality Control									
155	Pick Kit	0.00							
<b>*155*</b>									
Packaging	Memo	0.00							
Packaging									
160	QC4- 100% Inspect kits for completeness	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									

DAS  
16  
9-89

13/3/14

QC

DAS  
06  
9-89

13/3/20

13/3/14

DAS  
27  
9-89

13.3.20

1

# Work Order ID 87918

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Item ID: D350-588-041

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Aft Door Assembly

Start Date: 7/18/12 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 8/17/12 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <b>FG020</b>	0.00							
<b>*170*</b>									
Packaging	Memo <b>REV-D</b>	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
<b>*180*</b>									
QC	Memo	0.00							
Quality Control									

**(1)** **8** **13-3-10**

**13/3/2010**

**ML5 13-03-20**

# Picklist Print

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Page 1

Work Order ID: 87918  
Parent Item: D350-588-041  
Parent Item Name: Aft Door Assembly

Start Date: 7/18/12 Required Date: 8/17/12  
Start Qty: 1.00 Required Qty: 1.00

Comments: IPP P 04.02.04ReformatKJ/DS IPP Rev:Q as per DSI9414 DD  
verified by:EC IPP Rev:R add pick kit DD 10.03.29 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN526C1032R7  
Screw

Purchased

No

155

Each

70.0000

2

2 11/23/13

CP

SMB

Location

Loc Qty

Loc Code

ST348

70

116304

10

119449

60

AN526C832R8  
Screw

Purchased

No

155

Each

127.0000

8

8 11/23/12

CS

SM

Location

Loc Qty

Loc Code

ST346

115

120717

15

122151

100

ST347

12

116410

3

116471

5

118926

4

AN526C832R9  
Screw

Purchased

No

140

Each

382.0000

8

8

123522 x 8

13-02-23

Location

Loc Qty

Loc Code

ST346

373

120181

21

121556

152

122151

200

ST347

9

118983

9

AN960JD10  
Washer

NAS1149D0363J

Purchased

No

140

Each

0.0000

2

2 13-02-23

AN960JD10  
Washer

NAS1149D0363J

Purchased

No

155

Each

0.0000

2

2 13/13/14

W

SM

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____				<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>					
<b>Root Cause</b>	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY									
<b>Landing Gear</b>			<b>General</b>						
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain	<input type="checkbox"/> Ovalized	<input type="checkbox"/> Pressure/Forced					
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Temperature/Cure					
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Weld					
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Wrong Stock Pulled					
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance	<input type="checkbox"/> Part Moved						
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Positioned Wrong						
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread	<input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Other					
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset							
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration							
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence							
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions							

# Picklist Print

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Work Order ID: 87918

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 7/18/12

Required Date: 8/17/12

Start Qty: 1.00

Required Qty: 1.00

D2143 Manufactured No  
Hinge Bracket

92166 x 1 140 Each 29.0000

1 13-02-23

Location	Loc Qty	Loc Code
ST	-28	
76100	10	
ST004	19	
82335	19	
ST198	38	

D2144 Manufactured No  
Hinge Bracket

92181 x 1 140 Each 7.0000

1 13-02-23

Location	Loc Qty	Loc Code
ST005	7	
78993	7	

D2150 Manufactured No  
Packer Doubler, Hinge

155 Each 36.0000

2 92182

Location	Loc Qty	Loc Code
ST005	36	
82136	16	
85513	20	

D2151 Manufactured No  
Packer Doubler, Hinge

155 Each 40.0000

2 92172

Location	Loc Qty	Loc Code
ST005	40	
82137	20	
85514	20	

D2153 Manufactured No  
Door Prop

155 Each 52.0000

1 95837  
95843

Location	Loc Qty	Loc Code
ST272	52	
78369	16	
85865	36	

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____				<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>					
<b>Root Cause</b>	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY									
<b>Landing Gear</b>			<b>General</b>						
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain	<input type="checkbox"/> Ovalized	<input type="checkbox"/> Pressure/Forced					
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Temperature/Cure					
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Weld					
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Wrong Stock Pulled					
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance	<input type="checkbox"/> Part Moved						
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Positioned Wrong	<input type="checkbox"/> Other					
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread	<input type="checkbox"/> Power Loss/Surge						
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset							
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration							
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence							
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions							



# Picklist Print

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Work Order ID: 87918

Parent Item: D350-588-041

Start Date: 7/18/12

Required Date: 8/17/12

Parent Item Name: Aft Door Assembly

Start Qty: 1.00

Required Qty: 1.00

**D2164**  
Stud Bracket

Manufactured No

155 Each 60.0000

**U**

1

*Smb*

Location Loc Qty Loc Code

ST005 60

64312 1

77024 3

82333 56

*82333*

**D2237**  
Striker Plate

Manufactured No

155 Each 62.0000

**2**

2

*91815*

*Smb*

Location Loc Qty Loc Code

ST006 42

64426 2

66139 1

82062 3

83376 36

ST009 20

85476 20

**D2445P**  
AFT DOOR ASSEMBLY

Purchased No

110 Each 0.0000

1

1

*87818*

**D2461**  
Neoprene "D" Seal  
(D2461-0870) cut (1) at 87.00"  
\*\*\* per kit\*\*\*

Manufactured No

155 f 684.4367

**7.25**

7.25

*Grease  
8/3/14*

*Smb*

Location Loc Qty Loc Code

ST402 184.436684

39782 6.5

55054 4

63880 14.8237

73644 159.112984

ST402A 500

85225 500

*82220*

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Work Order ID: 87918

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 7/18/12

Required Date: 8/17/12

Start Qty: 1.00

Required Qty: 1.00

D2463 Manufactured No

Seal

(D2463-0870) cut (1) at 87.00"  
\*\*\*\* per kit\*\*\*\*

64944

140 f 479.3174 7.25 7.25

~~87 13-02-23~~

Location	Loc Qty	Loc Code
ST404	479.31737	
72232	15.38	
79478	0.43737	
83542	463.5	

D2585 Manufactured No

Mounting Channel

391960 x1

140 Each 72.0000

2 2

~~87 13-02-23~~

Location	Loc Qty	Loc Code
ST011	72	
73297	2	
82029	20	
83369	6	
85425	44	

D2586 Manufactured No

Door Latch

89150

140 Each 100.0000

2 2

~~87 13-02-23~~

Location	Loc Qty	Loc Code
ST203A	100	
78833	1	
83893	99	

D2589  
Keys, Key Chain, 350 Hinge

ShP

Manufactured No

155 Each 0.0000

1

58194

D2621  
Latch Plate, 350 Spacepod

Manufactured No

140 Each 31.0000

2 2

~~87 13-02-23~~

Location	Loc Qty	Loc Code
ST013	31	
78991	19	
86368	12	

x2

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Work Order ID: 87918

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 7/18/12

Required Date: 8/17/12

Start Qty: 1.00

Required Qty: 1.00

D2690-17

Cable

Manufactured

No

155

Each

31.0000

1

1

SMD

## Location

## Loc Qty

## Loc Code

ST016

31

64786

1

66510

1

84069

19

85866

6

86649

4

85866

D2857-1

Hinge Bracket

Manufactured

No

140

Each

28.0000

1

1

91914 x 1

ET 13-02-23

## Location

## Loc Qty

## Loc Code

ST019

28

75253

4

82261

24

D2857-2

Hinge Bracket

Manufactured

No

140

Each

16.0000

1

1

85806 x 1

ET 13-02-23

## Location

## Loc Qty

## Loc Code

ST019

16

78904

16

D2858-1

Hinge Bracket

Manufactured

No

155

Each

37.0000

1

1

SMB

## Location

## Loc Qty

## Loc Code

ST019

37

63695

1

77019

12

82337

24

82337

D2858-2

Hinge Bracket

Manufactured

No

155

Each

32.0000

1

1

SMB

## Location

## Loc Qty

## Loc Code

ST019

32

64787

1

77020

8

82336

23

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Page 1

# Picklist Print

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Work Order ID: 87918

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 7/18/12

Required Date: 8/17/12

Start Qty: 1.00

Required Qty: 1.00

PG-778150-550-ROL

7781 9oz Glass 50"x125yd

CUT ONE SQUARE FEET PER KIT

Purchased

No

155

sf

2,764.4910

1

1

123239

Handwritten initials and marks.

Location

Loc Qty

Loc Code

CA

2764.491

104845

3

108932

18

111166

392

113905

564

117602

664.651

119099

1122.84

Smp

MS20426AD3-4

RIVET

Purchased

No

155

Each

2,552.0000

12

12

123021

Handwritten initials and marks.

Location

Loc Qty

Loc Code

ST316

2552

104374

236

110398

2316

Smp

MS20470AD4-5

Rivet, Universal Head

Purchased

No

155

Each

1,136.0000

18

18

122452

Handwritten initials and marks.

Location

Loc Qty

Loc Code

ST319

1136

118405

389

120142

747

Smp

MS21042L08

Nut

Purchased

No

140

Each

833.0000

8

8

123900 x8

13-02-23

Location

Loc Qty

Loc Code

ST300

33

121524

33

ST317

800

122141

800

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# Picklist Print

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Work Order ID: 87918

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 7/18/12

Required Date: 8/17/12

Start Qty: 1.00

Required Qty: 1.00

MS21042L08

Nut

Purchased

No

155

Each

833.0000

10

10

123900

SM

Location

Loc Qty

Loc Code

ST300

33

121524

33

ST317

800

122141

800

MS21042L3

Nut

Purchased

No

140

Each

3,107.0000

2

2

123900 x 2

87 13-02-23

Location

Loc Qty

Loc Code

ST300

1107

117885

32

119017

757

119075

138

121444

180

ST317

2000

122141

2000

MS21042L3

Nut

Purchased

No

155

Each

3,107.0000

4

4

M123900 (1) 5/13/14

SK

Location

Loc Qty

Loc Code

ST300

1107

117885

32

119017

757

119075

138

121444

180

ST317

2000

122141

2000

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# Picklist Print

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Work Order ID: 87918

Parent Item: D350-588-041

Parent Item Name: Aft Door Assembly

Start Date: 7/18/12

Required Date: 8/17/12

Start Qty: 1.00

Required Qty: 1.00

MS27039-08-11  
Screw

Purchased

No

155

Each

59.0000

2

2

123700

Location

Loc Qty

Loc Code

ST290

7

117441

7

ST292

52

116289

2

120833

50

120833

MS27039-1-15

Screw

Purchased

No

140

Each

31.0000

2

2

123352

21 13 02-23

Location

Loc Qty

Loc Code

ST291

31

118574

2

119736

1

121243

28

NAS1149DN832J

WASHER

Purchased

No

140

Each

409.0000

8

8

123900 x 8

21 13-02-23

Location

Loc Qty

Loc Code

ST298

409

119717

41

120422

368

NAS1149DN832J  
WASHER

Purchased

No

155

Each

409.0000

16

16

M123900

Location

Loc Qty

Loc Code

ST298

409

119717

41

120422

368

13/3/14

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Shop Packet Print

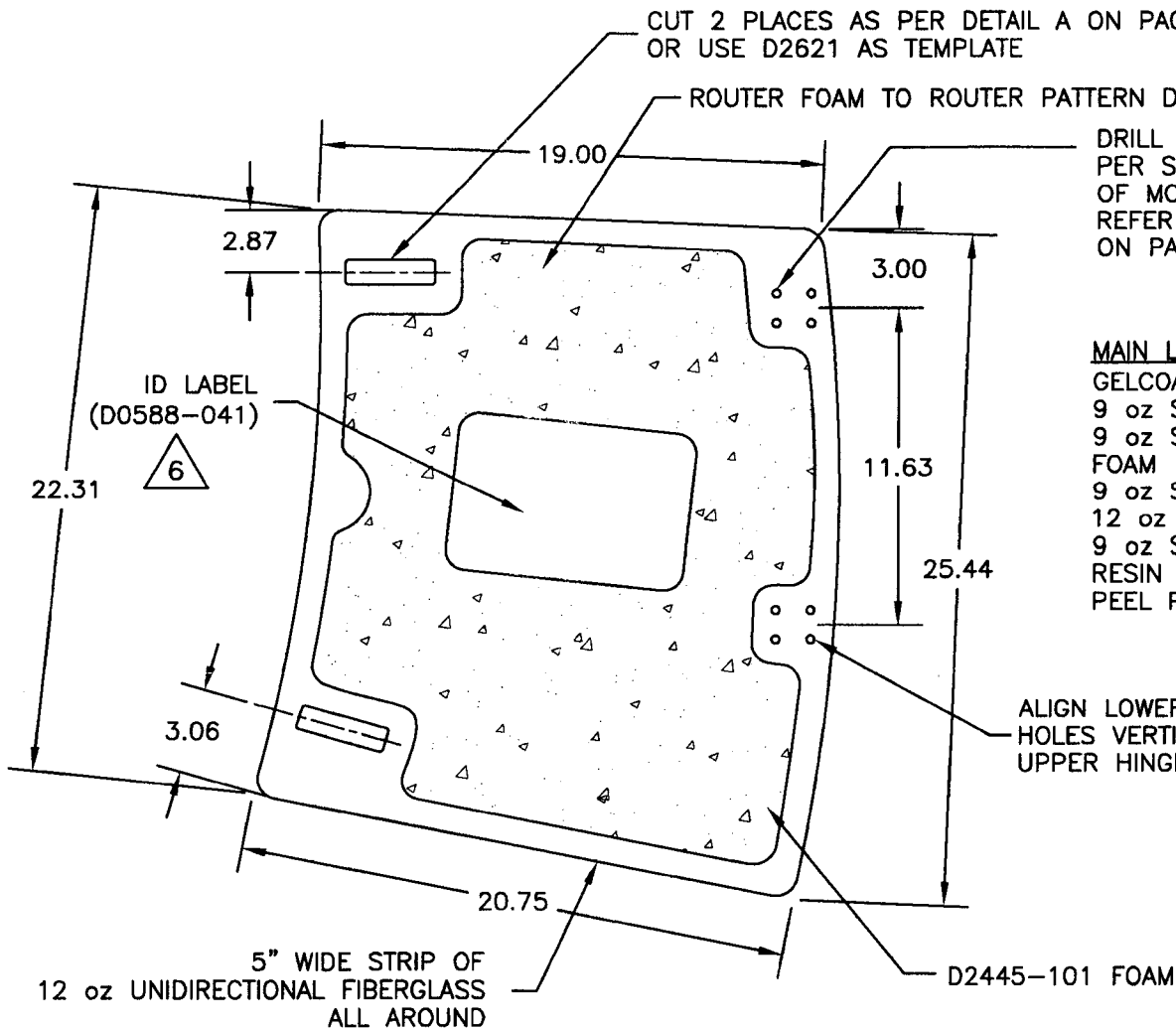
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**DART**

DESIGN <b>JB</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2445	REV. D SHEET 1 OF 2
DATE 06.06.09		TITLE AFT BAGGAGE DOOR	SCALE 1:7
A	97.07.15	NEW ISSUE	
B	02.01.24	ADD D2621; D2445-101	
C	04.02.09	REMOVE D2621; UPDATE NOTES	
D	06.06.09	ADD DIMENSIONS TO PERIMETER	

**RELEASED**06.11.13 *[Signature]*CUT 2 PLACES AS PER DETAIL A ON PAGE 2  
OR USE D2621 AS TEMPLATE

ROUTER FOAM TO ROUTER PATTERN DT8035

DRILL 8 HOLES  $\varnothing 0.171$   
PER SCRIBE LINES  
OF MOLD DT8036 OR  
REFER TO DETAIL B  
ON PAGE 2**MAIN LAYUP**GELCOAT #GEL 944W005  
9 oz SATIN  
9 oz SATIN  
FOAM  
9 oz SATIN  
12 oz UNIDIRECTIONAL  
9 oz SATIN  
RESIN  
PEEL PLYALIGN LOWER HINGE  
HOLES VERTICALLY WITH  
UPPER HINGE HOLES**NOTES:**

- 1) USE MOLD DT8036 FOR DOOR LAYUP. TRIM AND DRILL PER DT8619
- 2) RESIN: DERAKANE 411/510A40/470-36
- 3) FOAM: 3/8" A500 CORE CELL OR DIVINYCELL OR AIREX OR KLEGECELL R-75
- 4) FIBRE: 9.7 oz 7781 WEAVE "S" GLASS ("9 oz SATIN")  
12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
- 5) BOND FOAM CORE TO LAMINATE USING POLYBOND B46F
- 6) LAMINATE LABEL USING SURFACE VEIL AND EPOXY RESIN.
- 7) LAMINATE PER DART QSI 006 4.0
- 8) LAMINATION SCHEDULE PER THIS DRAWING
- 9) FINISH INSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 10) ALL DIMENSIONS ARE IN INCHES
- 11) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

CZ 12/07/18

W10: 87918

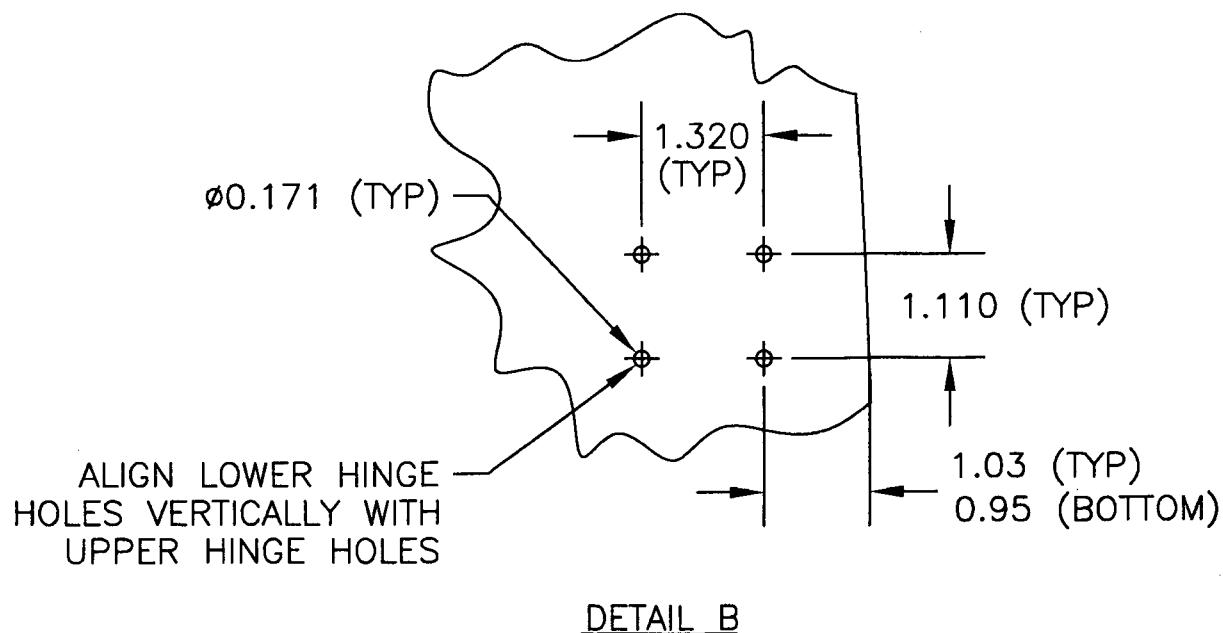
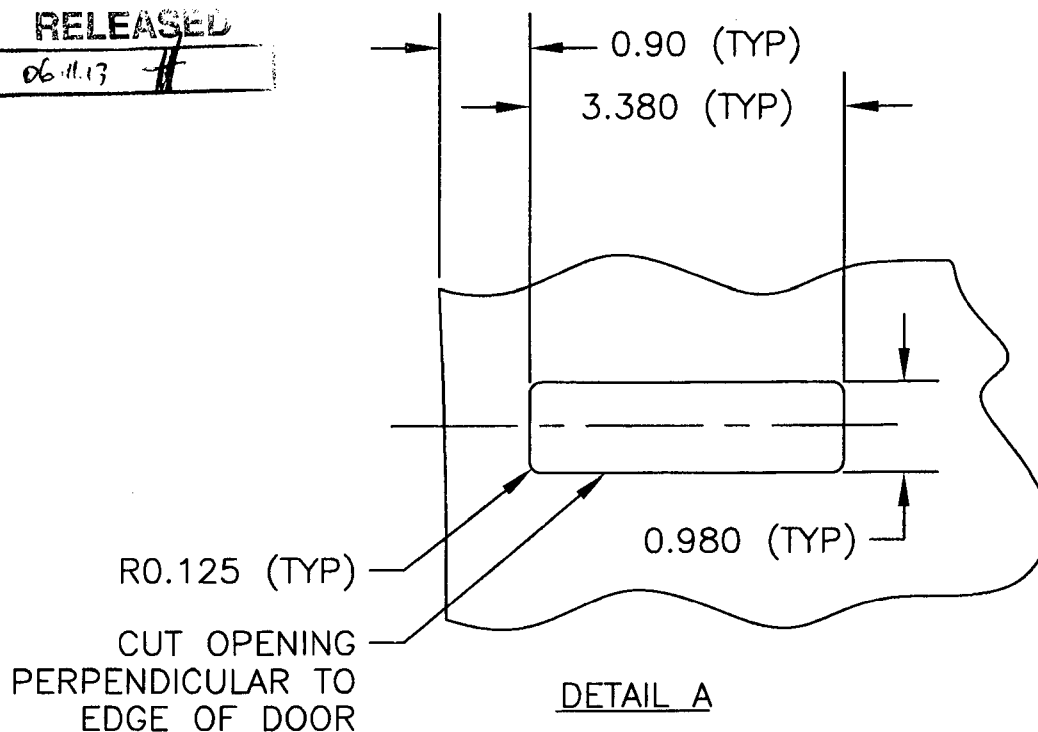
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DESIGN JB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2445	REV. D SHEET 2 OF 2
DATE 06.06.09		TITLE AFT BAGGAGE DOOR	SCALE 1:2

RELEASED  
06.11.13 *[Signature]*



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DELASTEK Inc.  
2699 5e Avenue  
Local 14, C.P. 10100  
Grand-Mère, Québec G9T 5K7  
Canada  
Tel.: (819) 533-5788  
Fax: (819) 533-3494

# PACKING SLIP

## CERTIFICATE OF COMPLIANCE

Invoice No.	46277
Customer No.	DART US

### Bill To

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Telephone : 613-632-5200  
Contact : Linda Lacelle

### Ship To

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Telephone : 613-632-5200  
Contact : Linda Lacelle

Ship Date	Order Date	Our SO #	Ordered by	Your PO#	Terms
03-01-2013	18-07-2012	21354	Chantal Lavoie	PO17478	Net 30 days USA
Ship Via		F.O.B.		Salesperson	GST/PST
Day & Ross Collect		Point de départ		Mathieu Veilleux, ext. 235	
Order Qty	B.O. Qty	Current Ship.	Item number	Description	
1	0	1	DKC134-0013	Line 1 D350-588-041 Aft Baggage Door (D2445) U of M: Chaque B87918 Drawing N° : D2445 Rév.: D Serial # B87918 Lot # 44190	

*It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request*

Accepted by:

Quality department



AQ-357

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.



DELASTEK Inc.  
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1270, Aberdeen Street  
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Canada

Telephone : 613-632-5200  
Contact : Linda Lacelle

Ship Date	Order Date	Our SO #	Ordered by	Your PO#	Terms
03-01-2013	18-07-2012	21354	Chantal Lavoie	PO17478	Net 30 days USA
Ship Via		F.O.B.		Salesperson	GST/PST
Day & Ross Collect		Point de départ		Mathieu Veilleux, ext. 235	
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*It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.*

Accepted by:

Quality department

AQ-357

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Date: Mardi, 2012-08-28 15:42:49  
Utilisateur: Daniel Montour

## Feuille de Procédé

Client : DART US DART AEROSPACE  
Numéro Job : 44190  
Numéro : 3959  
Numéro B.A. :  
Cette fois : 2012-08-28 No. :  
Prsht Rev. : NC  
Prem. fois : - - Type :  
Job précédente : 44188

Nom Dessin : N° D2445, AFT BAGGAGE DOOR  
Numéro Article : DKC134-0013  
Numéro Dessin : -  
Projet Numéro : DK-362  
Révision dessin :  
Matériel : Composite  
Date Dûe : 2012-09-04

Qte: 1 Ud UNITE

Écrit par :  
Vérifié & Approuvé par :  
Commentaires : N° de pièce Client: D2445 rev. D

E.O.: N/A

Feuille de Procédé Rév.: 04 déplacer collage du label  
après primer, ajout 2ieme étape de finition et de primer

Formulaire d'inspection: N/A

## Produit additionnel

Numéro Job:



# Séq.: Machine ou Description :

1.0 AAC1616 N° 83634, Frekote Loctite Wolo

Comment Qty.: 0.200 UNITE(s)/Unit Total: 0.200 UNITE(s)  
N° 83634, Frekote Loctite Wolo # de Lot: 1-37420-1

2.0 PREP-GENERAL Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire la préparation du moule N° DT-8036 selon IG 0009.

Date: 3/12/12



3.0 AMB0350 Gel Coat Blanc N° Gel 944W005

Comment Qty.: 0.200 KILOGRAMME(s)/Unit Total: 0.200 KILOGRAMME(s)  
Gel Coat Blanc N° Gel 944W005 N° de Lot: 1-37214-2

4.0 AMB0286 Catalyst N° DDM-9

Comment Qty.: 0.0320 GALLON(s)/Unit Total: 0.0320 GALLON(s)  
Catalyst N° DDM-9 N° de Lot: 1-87829-1

5.0 PREP-GENERAL Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% catalyst par  
quantité de résine.

Date: Mardi, 2012-08-28 15:42:49

Utilisateur: Daniel Montour

## Feuille de Procédé

Client: DART US DART AEROSPACE  
Numéro Job: 44190Nom Dessin: N° D2445, AFT BAGGAGE DOOR  
Numéro DKC134-0013

Numéro Job:



# Séq.: Machine ou Opération:

Description :

Date: 3/12/12 Sceau:



6.0

GEL COAT

Application du Gel Coat



Comment Setup: 0.00Hrs/ Run: 0.0000Min. Total Run : 0.0000Hrs

Faire l'application du Gelcoat selon IG 0019

Date: 3/12/12 Sceau:



7.0

AAC1885

Tissu à délaminer Release ply B

Comment Qty.: 1.52 VERGE(s)/Unit Total : 1.52 VERGE(s)

Tissu à délaminer Release ply B

# de Lot: N/A

8.0

AAC1887

Wrightlon 5200 Bleu P3

Comment Qty.: 3.33 VERGE(s)/Unit Total : 3.33 VERGE(s)

Wrightlon 5200 Bleu P3

# de Lot: N/A

9.0

AC0885

Feutre de drainage N° Airweave N 10

Comment Qty.: 2.78 VERGE(s)/Unit Total : 2.78 VERGE(s)

10.0

AC0943

Stretchlon 200 poche à vide Vert

Comment Qty.: 2.00 PIED(s)/Unit Total : 2.00 PIED(s)

11.0

AMB0214

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

Comment Qty.: 2.0 VERGE(s)/Unit Total : 2.0 VERGE(s)

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

N° de Lot: 1-36539-2

12.0

AMB0511

N° TG 13 U, Fiberglass 13 oz

Comment Qty.: 0.33 VERGE(s)/Unit Total : 0.33 VERGE(s)

N° TG-13-U, Fiberglass 13 oz

N° de Lot: 1-36302-1

13.0

AC0886

Ruban à gommer jaune #: T/AT-200Y

Comment Qty.: 1.2500 ROULEAU(s)/Unit Total : 1.2500 ROULEAU(s)

14.0

PREP-GENERAL

Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Tailler le matériel, selon les différents patrons de découpe comme suit:

4 plis de tissus de 9.7 oz.

1 pli de 13 oz. pour tout le contour de la pièce par 5" de large.

3 fois le sac à vide Stretchlon 200.

3 fois le film perforé P-3

3 fois le feutre de drainage

2 fois le tissu à délaminer ( non nécessaire lors du bagging du core ).

Appliquer le ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.

Date: Mardi, 2012-08-28 15:42:49

Utilisateur: Daniel Montour

## Feuille de Procédé

Client: DART US DART AEROSPACE

Nom Dessin: N° D2445, AFT-BAGGAGE DOOR

Numéro Job: 44190

Numéro DKC134-0013

Numéro Job:



# Séq.:

Machine ou Opération:

Description :

Afin d'accélérer le processus de taillage, tailler les plis de 9.7 oz. tous en même temps, en les superposant les uns sur les autres.

Date: 3/12/12

Sceau:



15.0

AMB0286

Catalyst N° DDM-9

Comment Qty.: 0.0130 GALLON(s)/Unit Total: 0.0130 GALLON(s)

Catalyst N° DDM-9

N° de Lot: 1-27829-1

16.0

AMB0212

Résine (411B7530) 411-350 promo. 75min.

Comment Qty.: 0.360 KILOGRAMME(s)/Unit Total: 0.360 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-38246-1

17.0

PREP-GENERAL

Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation de la résine selon les quantité requises, mix ratio 1.5% de catalyst N° DDM-9 par quantité de résine N° 411-350.

Date: 3/12/12

Sceau:



18.0

LAMINAGE

Faire le laminage



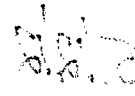
Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moule N° DT 8036 et ensuite imbiber un plis de tissu 9.7 oz.

Recommencer l'opération pour le deuxième pli.

Date: 3/12/12

Sceau:



19.0

BAGGING

Faire le bagging sur la pièce



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

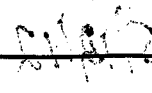
Faire la poche à vide selon IG 0012.

Laisser sécher pendant 4 heures minimum.

Heure Curing début: 3:00 Heure Curing Fin: 8:15

Date: 3/12/12

Sceau:



Date: Mardi, 2012-08-28 15:42:49

Utilisateur: Daniel Montour

## Feuille de Procédé

Client: DART US DART AEROSPACE

Nom Dessin: N° D2445, AFT BAGGAGE DOOR

Numéro Job: 44190

Numéro DKC134-0013

Numéro Job:



# Séq.: Machine ou Opération: Description :

20.0 AMB0286 Catalyst N° DDM-9

Comment Qty.: 0.0042 GALLON(s)/Unit Total: 0.0042 GALLON(s)  
Catalyst N° DDM-9 N° de Lot: 1-27829-1

21.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Comment Qty.: 0.120 KILOGRAMME(s)/Unit Total: 0.120 KILOGRAMME(s)  
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-38246-1

22.0 PREP-GENERAL

Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire la préparation de la résine selon les quantités requise, mix ratio 1.5% de catalyst N°  
DDM-9 par quantité de résine N° 411-350, Imbiber toutes les surfaces du Foam Core  
selon IG0105

Date: 5/12/12 Sceau:



23.0 AAC1611

Polybond B46F

Comment Qty.: 0.045 KIT(s)/Unit Total: 0.045 KIT(s)  
Polybond B46F N° de Lot: 1-29434-1

24.0 DKC134-0029

Foam Core N° D2445-101 ( Pour AFT Baggage Door )

Comment Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)

Foam Core N° D2445-101 ( Pour AFT Baggage Door )

N° de Job: 43689

25.0 ASSEMBLAGE

Assemblage mécanique



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Assembler le DKC134-0029 selon IG 0033

Date: 5/12/12 Sceau:



26.0 BAGGING

Faire le bagging sur la pièce



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire la poche à vide selon IG 0012

Retirer le bagging avant la fin de la polymérisation (entre 1h et 1h30) afin d'enlever le  
surplus de Polybond.

Heure début Curing: 10:25

Heure Fin Curing: 11:30

Date: 5/13/12 Sceau:



Date: Mardi, 2012-08-28 15:42:49

Utilisateur: Daniel Montour

## Feuille de Procédé

Client: DART US DART AEROSPACE

Nom Dessin: N° D2445, AFT BAGGAGE DOOR

Numéro Job: 44190

Numéro DKC134-0013

Numéro Job:



# Séq.: Machine ou Opération: Description :

27.0 AMB0286 Catalyst N° DDM-9

Comment Qty.: 0.1360 GALLON(s)/Unit Total: 0.1360 GALLON(s)  
Catalyst N° DDM-9 N° de Lot: 1-27827-1

28.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Comment Qty.: 0.360 KILOGRAMME(s)/Unit Total: 0.360 KILOGRAMME(s)  
Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1-38246-1

29.0 PREP-GENERAL Préparation du matériel



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% de catalyst  
N° DDM-9 par quantité de résine N° 411-350

Date: 6/12/12 Sceau:



30.0 LAMINAGE Faire le laminage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire le laminage d'un pli de 9.7 oz.

Faire le laminage du plis de tissu 13 oz. tout le tour de la porte en prenant bien soin que  
les deux bandes allant dans le coin droit en bas se superposent

Faire le laminage du dernier pli de 9.7 oz.

Date: 6/12/12 Sceau:



31.0 BAGGING Faire le bagging sur la pièce



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire la poche à vide selon IG 0012

Laisser sécher pendant 4 heures minimum.

Heure Curing Début: 8:45 Heure Curing Fin: 8:00

Date: 6/12/12 Sceau:



Date: Mardi, 2012-08-28 15:42:49

Utilisateur: Daniel Montour

## Feuille de Procédé

Client: DART US DART AEROSPACE  
Numéro Job: 44190Nom Dessin: N° D2445, AFT BAGGAGE DOOR  
Numéro DKC134-0013

Numéro Job:



# Séq.: Machine ou Opération: Description :

32.0 DÉMOULAGE Démoulage de la pièce



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Démouler la pièce en faisant bien attention aux coins &amp; Edges.

Date: 7/2/12 Sceau:

33.0 TRIMAGE Trimage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

À l'aide du gabarit N°DT 8619 trimer la pièce en utilisant un router muni d'un couteau 1/4" et d'un " Bushing " 1/16" de mur.

Percer les " Latch " et les trous de peinture selon le dessin N° D2445.

Date: 10/2/12 Sceau:

34.0 AAC1492 N° P-15-3, Adtech Micro Ultra Filler

Comment Qty.: 0.014 GALLON(s)/Unit Total : 0.014 GALLON(s)  
N° P-15-3, Adtech Micro Ultra Filler # de Lot: 1-37873-1

35.0 FINITION Finition Générale



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire les réparations de finition s'il y a lieu à l'aide du "Filler" P15-3.

Date: 10/2/12 Sceau:

36.0 AAC1021 Dupont Primer N° 7704S

Comment Qty.: 0.0280 UNITE(s)/Unit Total : 0.0280 UNITE(s)  
Dupont Primer N° 7704S N° de Lot: 1-34195-2

37.0 AAC1101 N° 7775S, Dupont Activator - Reducer Chromabase

Comment Qty.: 0.0280 UNITE(s)/Unit Total : 0.0280 UNITE(s)  
N° 7775S, Dupont Activator - Reducer Chromabase N° de Lot: 1-36256-3

38.0 PRIMER Application primer



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run.: 0.0000Hrs

Faire la préparation et l'application du primer batisseur selon I.G. 0008

Date: 11/12/12 Sceau: # de fiche de mélange: N/A



Date: Mardi, 2012-08-28 15:42:49

Utilisateur: Daniel Montour

## Feuille de Procédé

Client: DART US DART AEROSPACE

Nom Dessin: N° D2445, AFT BAGGAGE DOOR

Numéro Job: 44190

Numéro DKC134-0013

Numéro Job:



# Séq.: Machine ou Opération: Description :

39.0 AAC1492 N° P-15-3, Adtech Micro Ultra Filler

Comment Qty.: 0.014 GALLON(s)/Unit Total: 0.014 GALLON(s)

N° P-15-3, Adtech Micro Ultra Filler

# de Lot: 1-38354-1

40.0 FINITION Finition Générale



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire les réparations de finition s'il y a lieu à l'aide du "Filler" P15-3.

Date: 17/12/12 Sceau:



41.0 AAC1605 Label N° D0588-041

Comment Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s)

Label N° D0588-041

N° de Lot: 37008

42.0 AAC1609 Surface Veil

Comment Qty.: 0.07 VERGE(s)/Unit Total: 0.07 VERGE(s)

Surface Veil

N° de Lot: N/A

43.0 AAC1220 Résine Mia-Poxy 100

Comment Qty.: 0.007 GALLON(s)/Unit Total: 0.007 GALLON(s)

Résine Mia-Poxy 100

N° de Lot: 1-25679-1

44.0 AAC1221 Durcisseur 95 Pour Résine Mia-Poxy

Comment Qty.: 0.007 QUART(s)/Unit Total: 0.007 QUART(s)

Durcisseur 95 Pour Résine Mia-Poxy

N° de Lot: 1-30095-3

45.0 ASSEMBLAGE Assemblage mécanique



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Coller le label N° D0588-041 selon IG 0111.

Date: 17/12/12 Sceau:



46.0 AAC1021 Dupont Primer N° 7704S

Comment Qty.: 0.0280 UNITE(s)/Unit Total: 0.0280 UNITE(s)

Dupont Primer N° 7704S

N° de Lot: 1-35377-2

47.0 AAC1101 N° 7775S, Dupont Activator - Reducer Chromabase

Comment Qty.: 0.0283 UNITE(s)/Unit Total: 0.0283 UNITE(s)

N° 7775S, Dupont Activator - Reducer Chromabase

N° de Lot: 1-36256-3

48.0 PRIMER Application primer



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire la préparation et l'application du primer final selon I.G. 0008

Date: Mardi, 2012-08-28 15:42:49  
Utilisateur: Daniel Montour

## Feuille de Procédé

Client: DART US DART AEROSPACE  
Numéro Job: 44190

Nom Dessin: N° D2445, AFT BAGGAGE DOOR  
Numéro DKC134-0013

Numéro Job:



# Séq.: Machine ou Opération: Description :

Date: 20-12-12 Sceau: 57 # de fiche de mélange: N/A

49.0 INSPEC FINAL Inspection finale



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'inspection selon le dessin N° D2445.

Date: 02/01/13 Sceau: QA-2

50.0 EMBAL / ENTREPO Emballage & Entreposage



Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire l'emballage des pièces selon IG 0057

Date: 3/01/13 Sceau: 53



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID PO17478

Purchase Order Date 7/18/12

PO Print Date 7/18/12

Page Number 1 of 1

Order From :

VU-DEL003

DELASTEK INC  
2699 5E AVENUE, LOCAL C.P 10100

GRAND-MERE, QC G9T 5K7  
CA

Contact Name

Vendor Phone 819 533 5788

Vendor Fax 819 533 3494

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

Terms

Currency

FOB

10127-2607

Net 30

USD

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

**FOXED**  
6/16/12

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2445P	AFT DOOR ASSEMBLY	8/17/12 Yes	1.00 Each	FedEx PI collect	\$580.0000	\$580.00
		Special Inst:	AS PER DWG D2445 REV. D B87918				
2	D2445P	AFT DOOR ASSEMBLY	8/17/12 Yes	1.00 Each	FedEx PI collect	\$580.0000	\$580.00
		Special Inst:	AS PER DWG D2445 REV. D B87153				
PO Total:							\$1,160.00

CERTIFICATE OF CONFORMITY  
REQ'D UPON DELIVERY

MATERIAL CERTIFICATION  
REQ'D UPON DELIVERY

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required - YES NO

Change Nbr: 1

Change Date: 7/18/12